

IN THE CLAIMS:

The text of all pending claims, (including withdrawn claims) is set forth below. Cancelled and not entered claims are indicated with claim number and status only. The claims as listed below show added text with underlining and deleted text with ~~strikethrough~~. The status of each claim is indicated with one of (original), (currently amended), (cancelled), (withdrawn), (new), (previously presented), or (not entered). Please AMEND claims * and ADD new claims * in accordance with the following:

1. (Currently Amended) A method of manufacturing an outer race used in a constant velocity universal joint of a tripod type, said constant velocity universal joint comprising a cup body and a shaft extending axially outwardly from a bottom of the cup body in a direction opposite to an open end thereof, said cup body having an inner peripheral surface formed with three axially extending track grooves, said cup body further including a radially outwardly protruding wall portion, aligned with each of the track grooves, and a radially inwardly depressed wall portion aligned with a reduced diameter portion of a peripheral wall of the cup body between each of the track grooves, said protruding and depressed wall portions being so defined as to alternate with each other in a direction substantially circumferentially of the cup body, each of the reduced diameter portions of the peripheral wall of the cup body adjacent the open end of the latter having a chamfered portion defined at a peripheral lip region of the open end of the cup body,

said method comprising:

in an upsetting operation, in which forming

a reduced diameter portion of a substantially cylindrical member, which eventually defines the shaft, and

a large diameter portion of the substantially cylindrical member with an axially inwardly depressed recess defined in an end face of the large diameter portion, the recess having a tapered peripheral wall face, which eventually defines the cup body a general shape of each of the chamfered portions, and respective shapes which eventually define the chamfered portions are formed by using an upsetting technique;

in a cup forming operation, forming a cup in the substantially cylindrical member by a combined pushing including a forward pushing and a rearward container pushing; and

in a drawing operation, to shape shaping the large diameter portion to a final design dimension and shape by using a drawing technique,

said upsetting operation being carried out prior to the cup forming operation, and said cup forming operation being carried out prior to said drawing operation.

2. (Previously Presented) A method of manufacturing an outer race used in a constant velocity universal joint of a tripod type, said constant velocity universal joint comprising a cup body and a shaft extending axially outwardly from a bottom of the cup body in a direction opposite to an open end thereof, said cup body having an inner peripheral surface formed with three axially extending track grooves, said cup body further including a radially outwardly protruding wall portion, aligned with each of the track grooves, and a radially inwardly depressed wall portion aligned with a reduced diameter portion of a peripheral wall of the cup body between each of the track grooves, said protruding and depressed wall portions being so defined as to alternate with each other in a direction substantially circumferentially of the cup body, each of the reduced diameter portions of the peripheral wall of the cup body adjacent the open end of the latter having a chamfered portion defined at a peripheral lip region of the open end of the cup body,

said method comprising:

an upsetting operation to make a generally elongated intermediate member having a small diameter portion and a large diameter portion with an axially inwardly depressed recess defined in an end face of the large diameter portion remote from the small diameter portion, said recess having a tapered peripheral wall face, which eventually defines a general shape of each of the chamfered portions;

a cup forming operation to shape the elongated intermediate member to a shape having the cup body by a combined pushing method including a forward pushing and a rearward container pushing; and

a drawing operation to shape the cup body to a final design dimension and shape by a drawing technique.

3. (Previously Presented) The outer race manufacturing method as claimed in Claim 2, wherein the cup forming operation is performed by the combined pushing method using a die to form the shaft and the cup body, and a straight punch to form the track grooves and the reduced diameter portions between the track grooves.

4. (Previously Presented) The outer race manufacturing method as claimed in Claim 2, wherein the drawing operation is carried out by using a die to form the cup body, and a punch to form the track grooves, the reduced diameter portions between the neighboring track grooves, and the chamfered portion at one end of each of the reduced diameter portions adjacent the open end of the cup body.

5. (Previously Presented) The outer race manufacturing method as claimed in Claim 3, wherein the drawing operation is carried out by using a die to form the cup body, and a punch to form the track grooves, the reduced diameter portions between the neighboring track grooves, and the chamfered portion at one end of each of the reduced diameter portions adjacent the open end of the cup body.

6. (Previously Presented) The outer race manufacturing method as claimed in Claim 2, further comprising an axial pushing operation, performed prior to the upsetting operation, to axially push a cylindrical rod member to form the small diameter portion and the large diameter portion of the elongated intermediate member, as well as an intermediate portion connecting the small and large diameter portions together and flaring outwardly in a direction from the small diameter portion towards the large diameter portion.

7. (Previously Presented) A method, of manufacturing an outer race used in a constant velocity universal joint of a tripod type, said outer race including a cup body having a chamfered portion defined at a peripheral lip region of an open end of the cup body, the method comprising:

elongating an intermediate member having a recess, said recess having a tapered peripheral wall face, which eventually defines a general shape of the chamfered portion;

subsequent to the elongating of the intermediate member, shaping the elongated intermediate member to a shape having the cup body; and

subsequent to the shaping of the elongated intermediate member to the shape having the cup body, shaping the cup body to a final design dimension and shape by a drawing technique.